



Boiler/Pipe System Welding Q&As

1. What are the general welding requirements in Wisconsin?

Answer: Rather than think in terms of general requirements, fabricators must ensure that welding procedures comply with all of the details of the adopted standard that applies to that specific type of work being completed.

Consult the applicable codes for the specific type of work:

- Structural steel welding for buildings use SPS 362.2208, welding with the adoption of AWS D1.1 and D1.3. Credential requirements are in the [SPS 305, Licensing, Certifications, and Registrations Code](#), specifically 305.34 and 305.35. Structural steel welders on job sites must have a valid wallet card issued by the Department of Safety and Professional Services, Industry Services Division.
- New boiler and pressure vessel construction welding requirements are contained in the SPS 341, Boilers and Pressure Vessels Code, which adopts ASME Boiler and Pressure Vessel Code, Sections 1 through 12; the National Board Inspection Code, NB-23; ASME B31.1 Power Piping; and ASME B31.3 Process Piping
- Refrigeration Systems: ASME B31.5 Refrigeration Piping Code; [SPS 345, Mechanical Refrigeration Code](#)
- Gas Systems: [SPS 340 Gas Systems Code](#); NFPA-54; NFPA-58
- Anhydrous Ammonia: [SPS 343, Anhydrous Ammonia Code](#); ANSI K61.1; ASHREA Codes
- Amusement Rides: [SPS 334, Amusement Rides Code](#)
- Elevators: [SPS 318 Elevators, Escalators and Lift Devices Code](#)

2. What are the visual welding inspections requirements?

Answer: Visual weld examination requirements differ based on the code that requires certain welding processes:

- Power piping visual examination requirements are defined in ASME B31.1, and 1.36.3.1.
- Personnel qualifications are specified in ASME B31.3 136.3.2 Qualifications of NDE Personnel.
- Specific examinations per B31.1 136.4.2
- ASME B31.3 Process Piping Code, see 342.1, 342.2, 344.2 and 344.2.2
- Refrigeration Piping, ASME B31.5, paragraphs 5.36.1, 5.36.2 and 5.36.4